









# Work Order ID 63037

Monday, October 18, 2010 1:01:43 PM





Page 1

Item ID: D3574-5 Accept  Setup Start   
Revision ID: Stop   
Item Name: Cabin Floor Protector  
Start Date: 10/18/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 10/26/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan:  Date: 10-10-10 Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100  FLOW WATER JET 0.00  
Waterjet Memo 0.00 B10-10-20  
FLOW CNC Waterjet 1-Cut as per Dwg D3574 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary 

110  QC2- Inspect parts off machine FAI/FAIB 0.00  
QC Memo 0.00 B10-10-20  
Quality Control

120  QC8- Inspect parts - second check 0.00  
QC Memo 0.00 2 10/10/21  
Quality Control A1272

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 63037**

Monday, October 18, 2010 1:01:43 PM



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Item ID: D3574-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

ES 10/10/21 (2)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SB 10/10/21

(2)

150



Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

0.00

Packaging

10/10/21 20 SF

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 63037**

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Monday, October 18, 2010 1:01:43 PM

Item ID: D3574-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22 *[Signature]*  
ME  
10-10-21

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 18, 2010 1:01:47 PM

Page 1

Work Order ID: 63037



Parent Item: D3574-5



Parent Item Name: Cabin Floor Protector

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04 Purchased No

sf

1,865.803

33.6

67.23362



GE PLASTICS LEXAN SHEET

10-10-20

Location

Loc Qty

Loc Code

MAT

1865.8038

115261

1865.8038

115261

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	63037
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	*		V B02	
7.37	+/-0.030	7.37	*		T B01	
11.00	+/-0.030	11.00	Ø		T	
15.25	+/-0.030	15.25	Ø		T	
25.87	+/-0.030	25.87	Ø		T	
39.75	+/-0.030	39.75	Ø		T	
44.75	+/-0.030	44.75	Ø		T	
49.11	+/-0.030	49.11	Ø		T	
51.11	+/-0.030	51.11	Ø		T	
1.75	+/-0.030	1.75	Ø		T	
58.38	+/-0.030	58.38	Ø		T	
63.50	+/-0.030	63.50	Ø		T	
65.25	+/-0.030	65.25	Ø		T	
11.87	+/-0.030	11.87	Ø		T	
14.75	+/-0.030	14.75	A		T	
26.00	+/-0.030	26.00	Ø		T	
40.87	+/-0.030	40.87	Ø		T	
45.00	+/-0.030	45.00	Ø		T	
48.00	+/-0.030	48.00	Ø		T	
55.13	+/-0.030	55.13	Ø		T	
58.38	+/-0.030	58.38	Ø		T	
61.25	+/-0.030	61.25	Ø		T	
61.88	+/-0.030	61.88	Ø		T	
64.63	+/-0.030	64.63	Ø		T	
7.63	+/-0.030	7.63	Ø		T	
11.00	+/-0.030	11.00	Ø		T	
22.50	+/-0.030	22.50	Ø		T	
35.13	+/-0.030	35.13	Ø		T	
36.50	+/-0.030	36.50	Ø		T	
40.00	+/-0.030	40.00	Ø		T	
41.88	+/-0.030	41.88	Ø		T	
43.63	+/-0.030	43.63	Ø		T	
6.75	+/-0.030	6.75	Ø		T	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43037
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 2 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50	X		T B 02	
10.38	+/-0.030	10.38	8		T	
14.50	+/-0.030	14.50	2		T	
16.75	+/-0.030	16.75	8		T	
19.00	+/-0.030	19.00	0		T	
24.13	+/-0.030	24.13	8		T	
33.88	+/-0.030	33.88	8		T	
39.50	+/-0.030	39.50	8		T	
40.25	+/-0.030	40.25	8		T	
43.50	+/-0.030	43.50	2		T	
43.83	+/-0.030	43.83	2		T	
46.60	+/-0.030	46.60	8		T	
0.125	+/-0.010	0.130	X		U B02	

<b>Measured by:</b> B	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 10-10-20	<b>Date:</b> 10/02/1	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	[Signature]

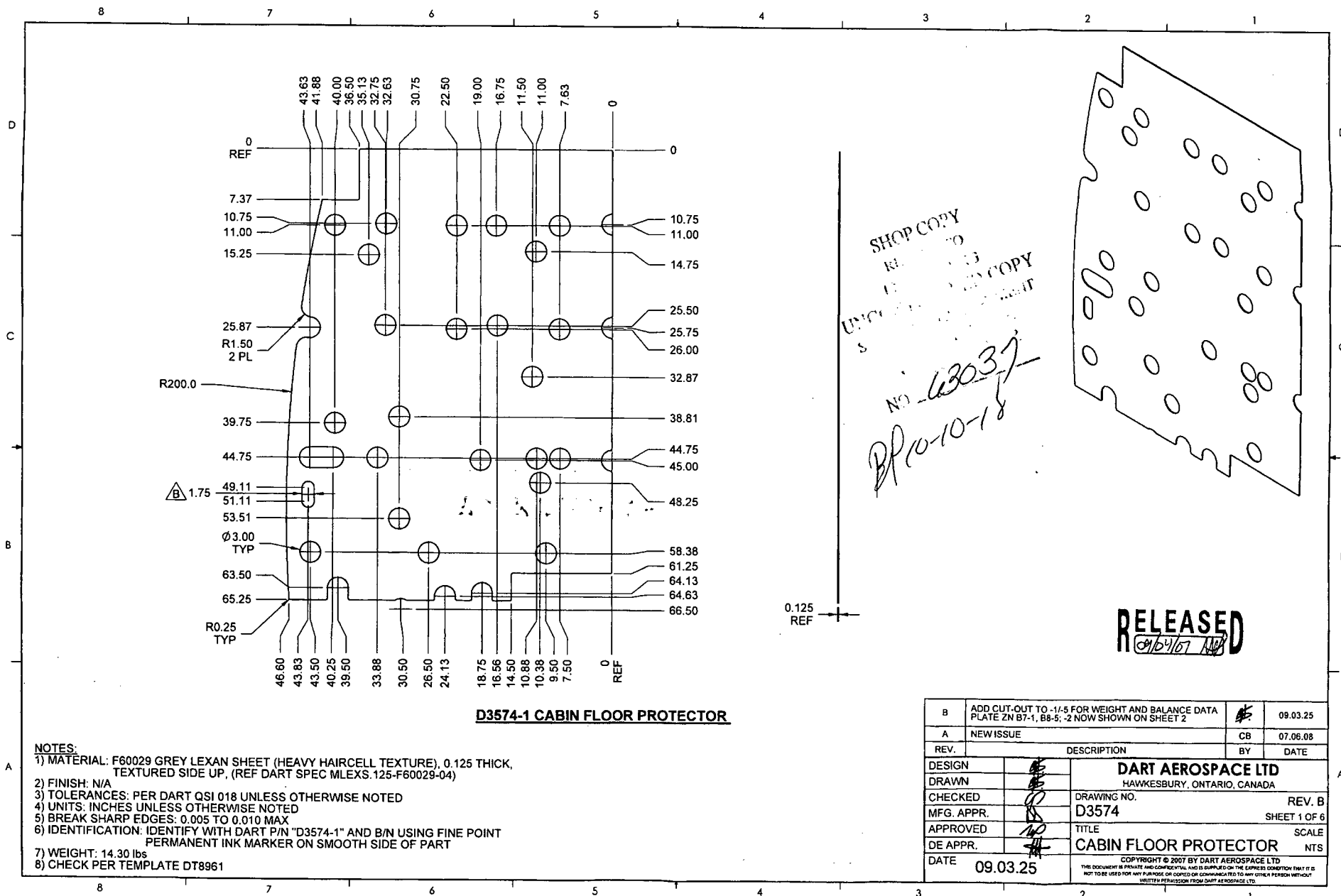
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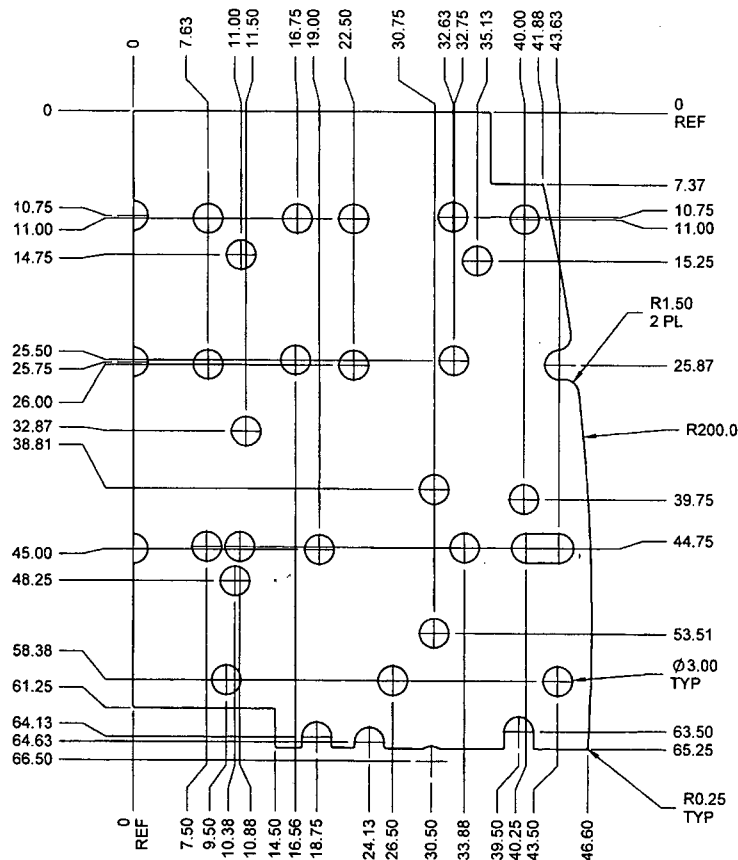
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3574-2 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

0.125  
REF

W/C 63037

**RELEASED**  
04/04/01 VHM

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3574</b>
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 6
DE APPR.		TITLE <b>CABIN FLOOR PROTECTOR</b>
DATE	09.03.25	SCALE NTS
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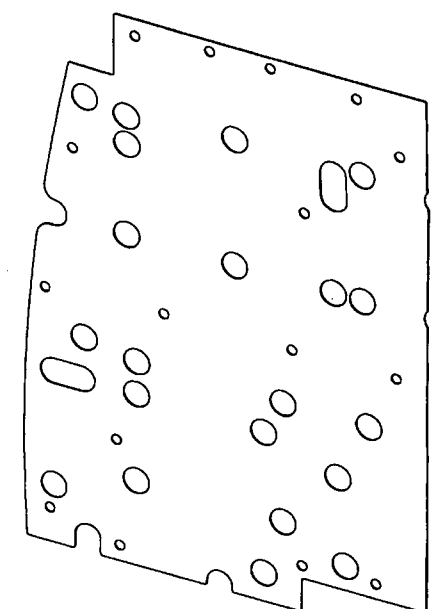
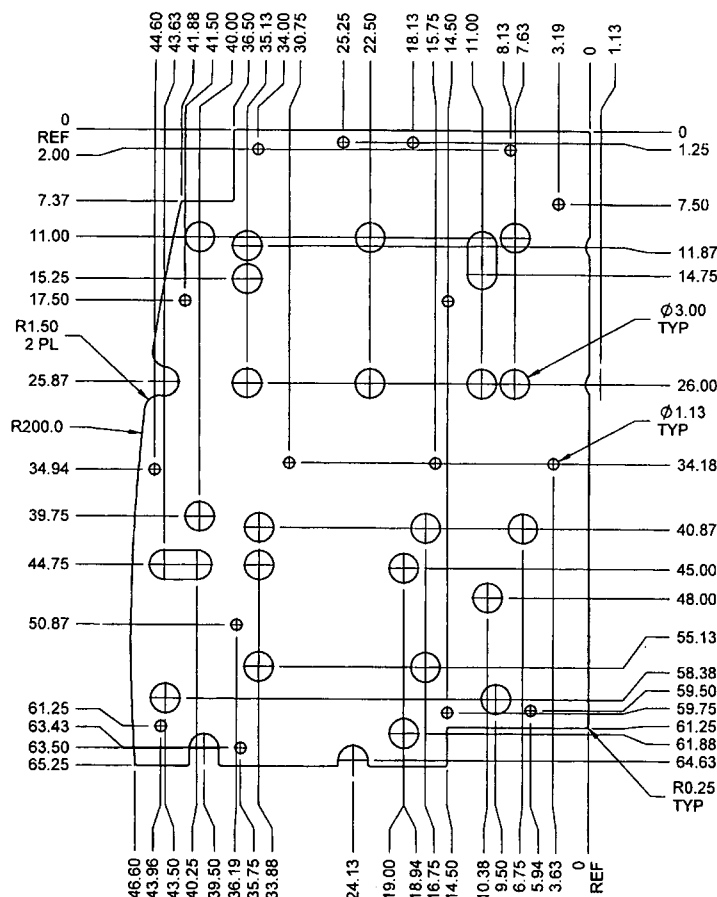
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



0.125  
REF

W6 63037

RELEASED  
9/14/07

### D3574-3 CABIN FLOOR PROTECTOR

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3574</b>	REV. B
MFG. APPR.		SHEET 3 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		<b>CABIN FLOOR PROTECTOR</b>	NTS
DATE	<b>09.03.25</b>	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

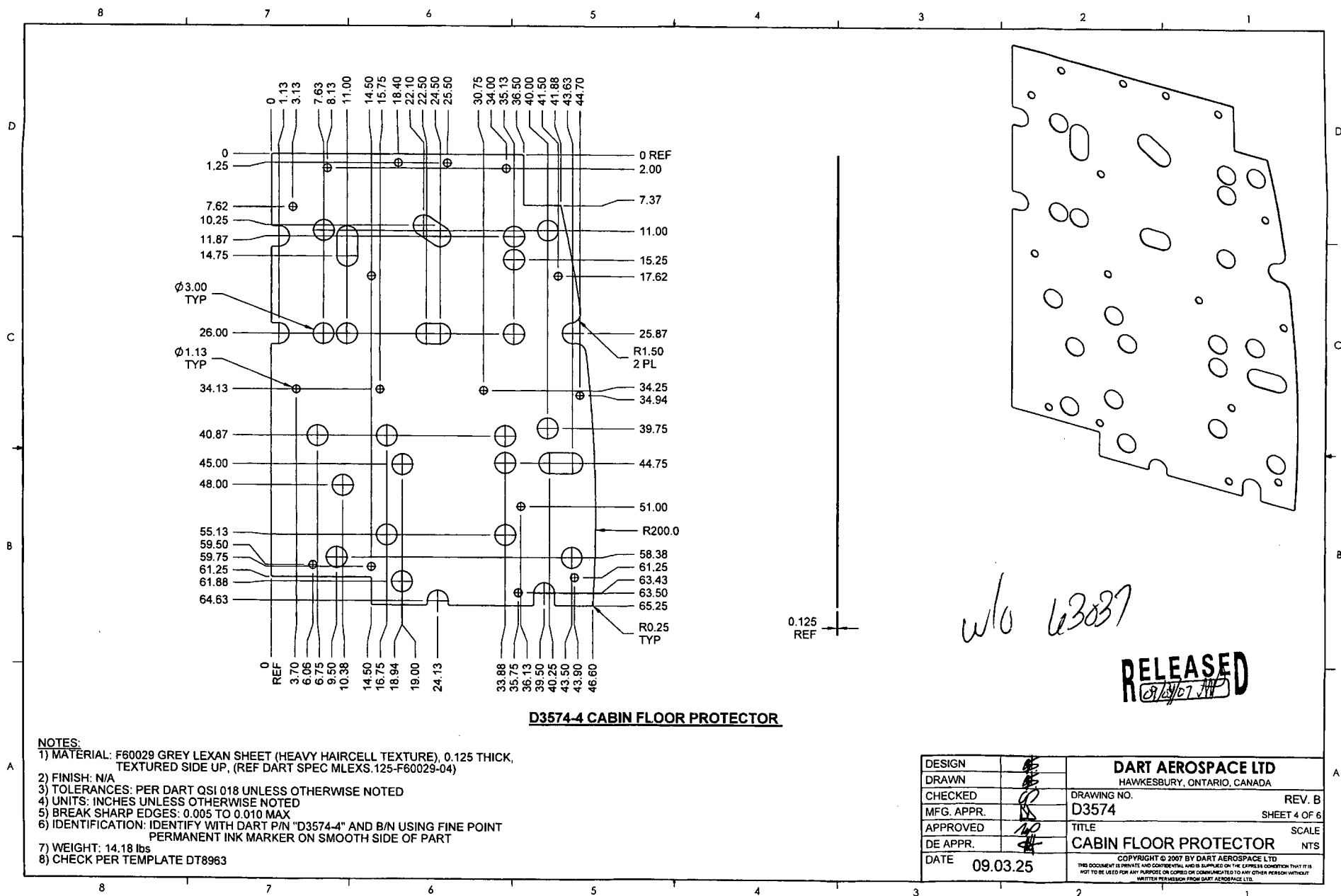
W/O:		WORK ORDER CHANGES					
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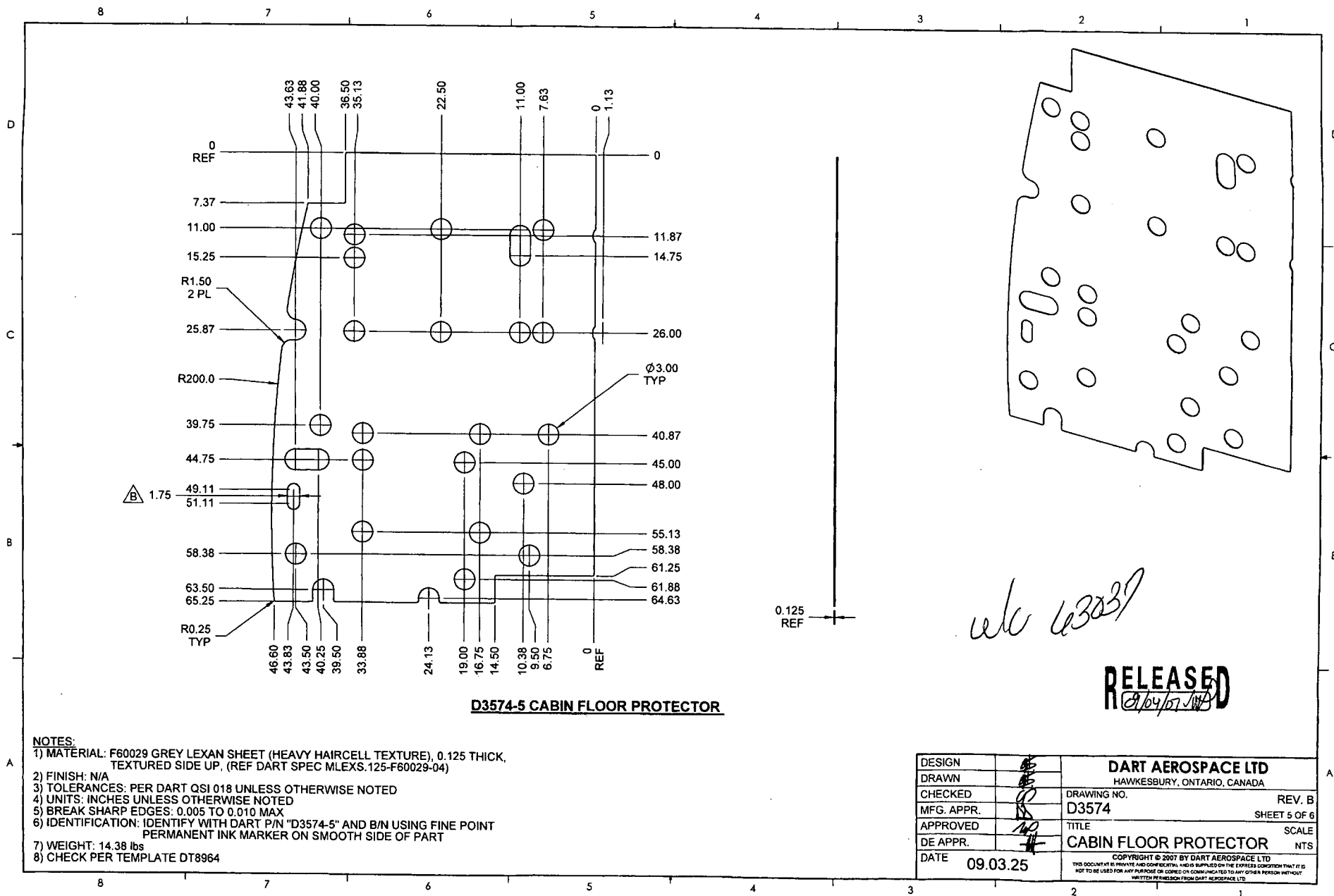
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